

Date: Wednesday, 4/19/2006 1:08:40 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SUPPORT GUSSET (350) BASKET		
Job Number	: 26741		Part Number	: D2325		
Estimate Number	: 10496		Drawing Number	: D2325 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 4/19/2006	S.O. No. : N/A	Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 4/26/2006		Qty: 50 Um: Each
Previous Run	: 25687					
Written By	: <u>Sepp Command Below</u>					
Checked & Approved By	: <u>Sepp 06.04.06</u>					
Comment	: Est. D 02.12.06 Reformat; Rev B KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 1043

Email or ship DXF file to vendor/Make as per Dwg D2325,

Material: 304 SS .063" Thick

Material release note required

C Ldc/04/20 (50)

2.0	D2325F	Support Gusset (350) Bask
-----	--------	---------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Support Gusset (350) Bask

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

6/04/06 51

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



6/05/06 51

Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

H-M 06/05/06

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/05/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/19/2006 1:08:40 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT GUSSET (350) BASKET

Job Number: 26741

Part Number: D2325

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGIN

Identify and Stock

Location: WS

AA 06/05/08 50

7.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

RG 06/05/08 50

Job Completion



4 da 05 08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

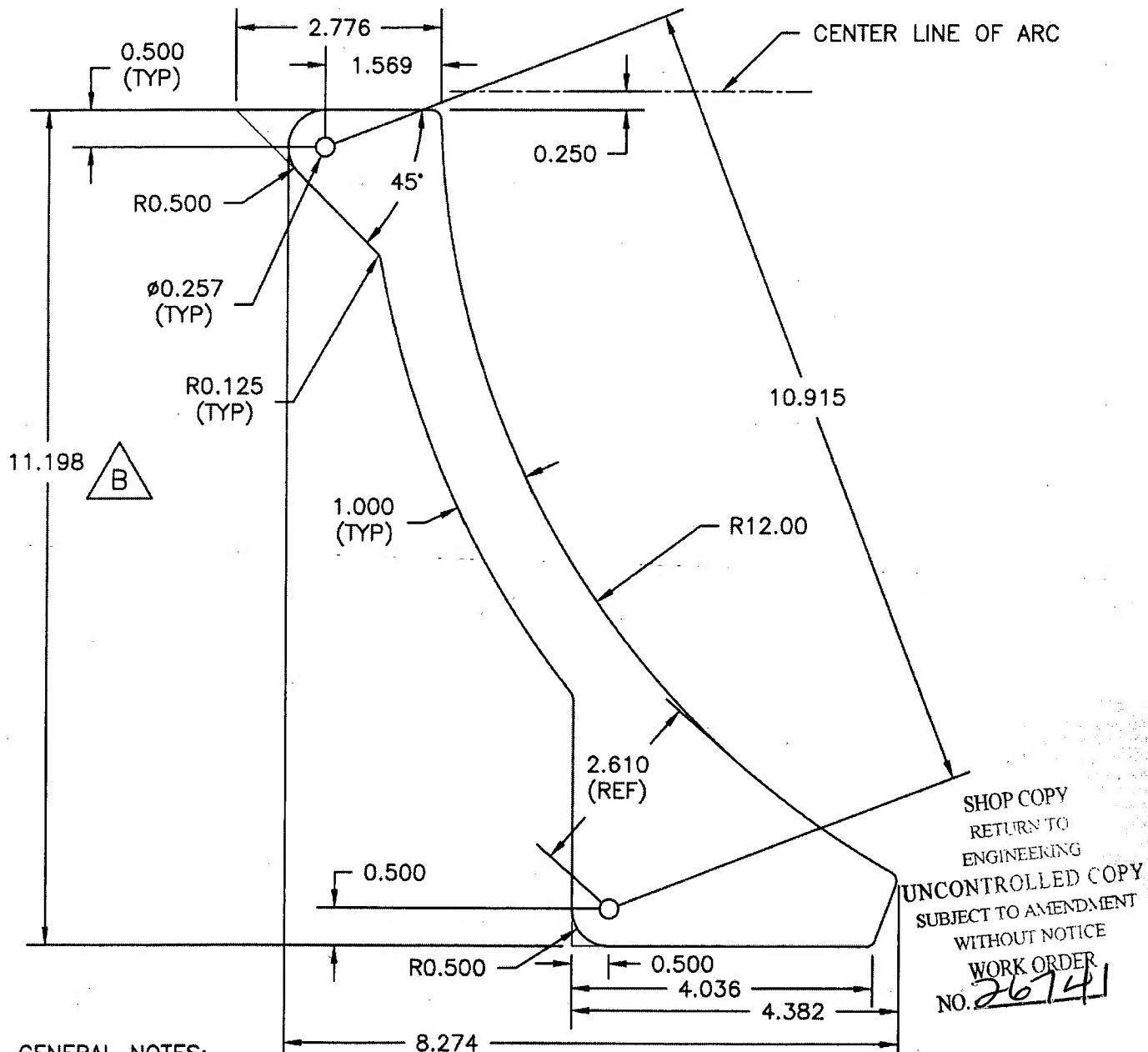
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>sf</i>	DRAWN BY <i>cp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>sf</i>	APPROVED <i>sf</i>	DRAWING NO. D2325	REV. B SHEET 1 OF 1	
DATE 02.08.28		TITLE SUPPORT GUSSET	SCALE 1:2	
A	94.12.13	NEW ISSUE		
B	02.08.28	REFORMAT; 11.198 WAS 11.948		

RELEASED
02.08.29



GENERAL NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK (REF DART SPEC. M304S16GA)
 - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



Paragraph 4.3 by TÜV Anlagentechnik GmbH (Neumünster) according to EN 10204-3.1B

Inspection Certificate EN10204-3.1B

P60124PC001

**Shanxi Taihang Stainless Steel CO., LTD Member
of Taiyuan Iron and Steel (Group) Co., LTD.**
NO.2 jiucaoping, Taiyuan, Shanxi, P.R.China
TEL: (0351)3013328 FAX: (0351)3017816
<http://www.tisco.com.cn>
E-mail: tgbkg@tisco.com.cn

MILL TEST CERTIFICATE

MATERIAL	AISI304 No.2B Finish	060504
SPECIFICATION	ASTM A240/A4460	ASME SA240/SA4460
L/C NO.		
CERTIFICATE NO.	20051187	
DATE OF ISSUE	/ /	

CUSTOMER
OLBERTCONTRACT NO.
1187DATA OF
2005/11/20

COIL	Product	Melting furnace	Inspectors stamp	Mark of the Manufacturer		
				E+VOD	Shanxi Taiyuan Stainless Steel Co.,ltd	
NO.	Heat No.	Coil No.	Quantity	Dimensions	Weight (kg)	
8.	4505286	SA9-495-1ZD	1	11GA × 48 × C	7009	
9	Y506019	SA9-485-1ZB	1	11GA × 48 × C	6679	
10	4505044	SA9-458-1ZY	1	14GA × 48 × C	5461	
11	4505274	SA9-450-1ZD	1	11GA × 48 × C	4832	
12	4505271	SA10-44-3ZJ	1	16GA × 48 × C	8905	
13	4505050	SA10-53-3ZJ	1	16GA × 48 × C	8617	
14	4505393	SA10-70-4ZY	1	14GA × 48 × C	8642	

Chemical Composition

Heat No.	C	Si	Mn	P	S	Cr	Ni	Cu	Al	Mo	N
4505286	0.060	0.470	1.400	0.017	0.033	18.170	8.020	0.010	0.010	0.010	0.035
Y506019	0.050	0.350	0.950	0.032	0.004	18.300	8.090	0.440	0.006	0.120	0.070
4505044	0.060	0.450	1.370	0.019	0.002	18.200	8.120	0.010	0.010	0.010	0.050
4505274	0.060	0.370	1.320	0.017	0.002	18.150	8.120	0.010	0.010	0.010	0.045
4505271	0.060	0.470	1.320	0.016	0.003	18.170	8.110	0.010	0.010	0.010	0.045
4505050	0.050	0.480	1.290	0.014	0.002	18.220	8.050	0.010	0.010	0.010	0.045
4505393	0.070	0.480	1.260	0.017	0.002	18.200	8.070	0.010	0.010	0.010	0.040

Mechanical Properties

Test No.	Tensile Rm N/mm ²	R _{0.2} Yield _{0.2%} N/mm ²	R _{p0.2} Yield _{0.2%} N/mm ²	Elongation A5%	Corrosion Tens	Hardness		
						HRB	HV	HRC
4505286-T	633	282		53		84 - 83		
Y506019-T	650	266		53		88		
4505044-T	673	307		59		83 - 83		
4505274-T	690	299		56		86 - 85		
4505271-T	700	326		54			126 - 126	
4505050-T	693	292		57			190 - 188	
4505393-T	680	299		60		86 - 85		

Surface and dimensions controlled:

Work Inspector *T.S. - S.S.*

P60124PC001V 3042B .062X48 HT 4505271 4505050

Page 2 of 3

MATERIAL TEST/INSPECTION CERTIFICATE


耶茂實業股份有限公司

YIEH MAU CORP.

INVOICE NO.: F05MB11

COMMODITY : PRIME COLD ROLLED STAINLESS STEEL SHEET

 地址:高雄市楠竹寮路1345號
 345, SETUN AN RD., LU CHU HSILANG
 KAOSHING TAIWAN R.O.C.
 TEL:07-6972885 FAX:07-6973006
 CERTIFICATE NO. F05MB11
 DATE OF ISSUE: 12/01/2005
 PAGE:23

90270957

 SPECIFICATION : AISI 304
 CUSTOMER : INTEGRIS METALS LTD.

ITEM NO.	SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties					Chemical Composition (%)											
			KGS	LBS			Tensile Test GL=50 mm																
							(N/mm ²)	(N/mm ²)	(%)	Y.S	T.S	E.L.	M.R.B	H.V	C	S	Mn	P	S	Ni	Cr	N	
AISI 304, NO.4 (S/C) FINISH, WITH 100 MIC. FILM ON MAIN SIDE, WITH BACK-PASS, SLITTED EDGE.																							
7426-3530	18GA\48"X144"	1	1,435	3,164	YU139529	4BS18584-12	296	655	53	89	164	4.6	51	99	33	6	895	1836	2.2				
7426-3539	18GA\60"X120"	1	1,424	3,139	YU137844	4BS18468A-11	308	701	50	83	165	4.7	50	117	31	5	804	1813	3				
7426-6159	16GA\48"X 96"	1	1,445	2,186	YU189710	4BS18697-14	297	639	52	84	168	3.8	49	110	34	3	812	1818	3.2				
7426-6159	16GA\48"X 96"	1	1,445	3,186	YU138710	4BS18697-15	297	639	52	84	168	3.8	49	110	34	3	812	1818	3.2				
7426-6288	16GA\48"X120"	1	1,452	3,222	YU139710	4BS18697-17	297	639	52	84	168	3.5	49	110	34	3	812	1818	3.2				
7426-6288	16GA\48"X120"	1	1,452	3,223	YU139710	4BS18697-18	297	639	52	84	168	3.5	49	110	34	3	812	1818	3.2				
7426-6343	16GA\60"X 96"	1	1,440	3,175	YU140033	4BS18976B-11	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7				
7426-6353	16GA\60"X120"	1	1,418	3,126	YU140033	4BS18976B-16	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7				
7426-6353	16GA\60"X120"	1	1,195	2,636	YU140033	4BS18976B-17	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7				
7426-6363	16GA\60"X144"	1	1,376	3,031	YU140033	4BS18976B-12	295	674	51	84	168	3.5	49	116	32	11	805	1804	2.7				
7426-6363	16GA\60"X144"	1	1,374	3,039	YU140033	4BS18976B-13	295	674	51	84	168	3.8	49	116	32	11	805	1804	2.7				
7426-6349	16GA\48"X120"	1	1,426	3,146	YU160207	4BS20305A-11	314	704	49	88	176	3.5	51	125	35	9	805	1818	1.8				
7426-6349	16GA\48"X120"	1	1,421	3,183	YU140207	4BS20305A-12	314	704	49	86	176	5.5	51	125	35	9	806	1818	1.8				
7426-6049	14GA\48"X120"	1	1,421	3,133	YU140207	4BS20305A-13	314	704	49	86	175	5.5	51	125	35	9	806	1818	1.8				
7426-9255	14GA\60"X120"	1	1,432	3,179	YU140018	4BS19451A-11	306	673	50	85	173	4.9	47	118	33	10	804	1830	2.8				
7427-7144	12GA\48"X120"	1	1,862	3,003	YU235779	4BS18646A-113	308	641	53	84	168	4.6	48	118	35	4	818	1822	3.4				
7427-7144	12GA\48"X120"	1	1,852	3,003	YU235779	4BS18646A-114	308	641	53	84	168	4.6	48	118	35	4	814	1822	3.4				
7427-7155	11GA\48"X 96"	1	1,473	3,247	YU140191	4BS20468A-113	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1				
7427-7155	11GA\48"X 96"	1	1,478	3,247	YU140191	4BS20468A-114	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1				
7427-7177	11GA\48"X120"	1	1,308	2,884	YU235346	4BS20448A-211	293	655	51	83	162	4.1	49	124	33	7	810	1817	3				
7427-7177	11GA\48"X120"	1	1,313	2,882	YU235346	4BS20448A-212	293	655	51	83	162	4.1	49	124	33	7	810	1817	3				
7427-7177	11GA\48"X120"	1	1,313	2,892	YU235346	4BS20448A-216	293	656	51	83	162	4.1	49	124	33	7	810	1817	3				
7427-7177	11GA\48"X120"	1	1,316	2,801	YU140191	4BS20468B-211	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1				
7427-7177	11GA\48"X120"	1	1,316	2,801	YU140191	4BS20468B-212	300	673	52	84	167	4.8	53	127	32	5	804	1806	3.1				
7426-8430	18GA\36"X144"	1	1,468	8,202	YU286224	4BS20818-114	305	652	54	84	168	4.2	52	128	33	8	802	1815	3.8				
7426-3420	18GA\36"X144"	1	1,453	8,203	YU286224	4BS20818-116	305	652	54	84	168	4.2	52	128	33	8	802	1815	3.8				

NO MERCURY CONTAMINATION

Bend tested good for all Heat No.

 WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
 BEEN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

- PRIME MATERIAL. NO DINGS, NO DENTS, NO SCRATCHES
- P.O. NO. 487684 (VANCOUVER)
- SALES CONTRACT NUMBER: F05MB11
- DOCUMENTARY CREDIT NUMBER: ILCMSPPC165

YEH MAU CORP.

